

# Work Order ID 78683

**\*78683\***

Page 1

January-12-12 10:55:47 AM

Item ID: D206-628-014

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step RH

Start Date: 12/01/2012 Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 10/02/2012 Req'd Qty: 3.00

**\*3\***

Customer:

22841

Reference:

Approvals:

Process Plan: M.C.J

Date: 12/01/12

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

DSI9500

A

IIN-D206-628

Rev F

100

DOCUMENT CONTROL

0.00

**\*100\***

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-014 CHG 006

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

for M.C.J 12-3-6 (3)

Pto →

12/3/6 J 130

W/O: 70603		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-628-24 PAR #: \_\_\_\_\_ Fault Category: Prod Eng NCR: Yes No DQA: NA Date: 12/3/17  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: MCJ Date: 12/03/17

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/03/17	#100	Parts missing on w/o to ILW. R.C. w/o not create correctly	<u>✓</u> 12/03/17	ADD missing parts to Kit was 114910432R M 117291 am x8 per Kit	<u>S</u> 12/3/17	<u>S</u> 12/3/17	<u>a</u> 12/03/17	<u>S</u> 12/3/17
				update Bom + w/o. ADD copy of Bom checked				<u>S</u> 12/3/17

NOTE: Date & initial all entries

# Dart Aerospace Ltd

W/O: 70603

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: D206-628-44

PAR #:

Fault Category: Prod Eng.

NCR: Yes No

DQA: *[Signature]*

Date: 12/3/17

12-1273

Resolution: *[Signature]*

Disposition: *[Signature]*

QA: N/C Closed: MJS

Date: 12/03/07

NCR:

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/03/17	#100	Parts missing on w/o to IZW. R.C. w/o not create correctly <i>LOA</i>	<i>[Signature]</i> 12/03/17	ADD missing parts to Kit was 114360432R in 117291 qty 18 per Kit	<i>[Signature]</i> 12/3/17	<i>[Signature]</i> 12/3/17	<i>[Signature]</i> 12/03/17	<i>[Signature]</i> 12/03/17
				UPDATE Bom + w/o. ADD copy of Bom for Ref.	<i>[Signature]</i> 12/3/17			<i>[Signature]</i> 12/03/17

NOTE: Date & initial all entries

# Work Order ID 78683

**\*78683\***

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January-12-12 10:55:47 AM

Item ID: D206-628-014 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Heli-Access-Step RH  
 Start Date: 12/01/2012 Start Qty: 3.00 **\*3\*** Cust Item ID:  
 Required Date: 10/02/2012 Req'd Qty: 3.00 **\*3\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130		0.00							
<b>*130*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-014								
	Location: _____								
	PPP Rev: <u>PTD 78685</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

ES  
DH

12/3/12 (3)

MCS 12/03/07

MF  
12-03-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January-12-12 10:55:51 AM

Page 1

Work Order ID: 78683

\*78683\*

Parent Item: D206-628-014

\*D206-628-014\*

Parent Item Name: Heli-Access-Step RH

Start Date: 12/01/2012

Required Date: 10/02/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM  
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:  
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD IPP  
 Rev:G per DSI9500 DD 10.03.01 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C4A

Purchased

No

110

Each

3,002.000

2

6

\*\*

M120799

\*AN3C4A\*

BOLT

Location

Loc Qty

Loc Code

ST350

3002

117313

2

117688

5

117872

10

118112

16

118451

2

118838

13

119749

954

120187

2000

AN4C13A

Purchased

No

110

Each

60.0000

4

12

\*\*

M120423

\*AN4C13A\*

BOLT

Location

Loc Qty

Loc Code

ST357

60

120187

60

AN4C14A

Purchased

No

110

Each

94.0000

4

12

\*\*

121316

\*AN4C14A\*

Bolt

Location

Loc Qty

Loc Code

ST357

94

118706

94

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

January-12-12 10:55:51 AM

Work Order ID: 78683

**\*78683\***

Parent Item: D206-628-014

**\*D206-628-014\***

Parent Item Name: Heli-Access-Step RH

Start Date: 12/01/2012

Required Date: 10/02/2012

Start Qty: 3.00

Required Qty: 3.00

AN4C15A

Purchased

No

110

Each

109.0000

4

\*\*

**\*AN4C15A\***

Bolt

Location

Loc Qty

Loc Code

ST358

109

115835

2

118628

7

118706

100

AN960C416

NAS1149C0463

Purchased

No

110

Each

0.0000

16

48

\*\*

**\*AN960C416\***

washer

D2731-7

Manufactured

No

110

Each

54.0000

4

12

\*\*

**\*D2731-7\***

Mounting Lug

Location

Loc Qty

Loc Code

ST468A

4

71860

4

ST469

50

D2732

Manufactured

No

110

f

294.7060

2

6

\*\*

**\*D2732\***

Rubber Extrusion

Location

Loc Qty

Loc Code

ST410

294.706

70987

294.706

D2841-042

Manufactured

No

110

Each

0.0000

1

3

\*\*

**\*D2841-042\***

Step Assembly RH, 206 Float

January-12-12 10:55:51 AM

Shop Packet Print

Page 2



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 3

Work Order ID: 78683

**\*78683\***

Parent Item: D206-628-014

**\*D206-628-014\***

Parent Item Name: Heli-Access-Step RH

Start Date: 12/01/2012

Required Date: 10/02/2012

Start Qty: 3.00

Required Qty: 3.00

D2845

Manufactured No

110

Each

33.0000

\*\*

2

6

**\*D2845\***

Arm

Location

Loc Qty

Loc Code

ST265

33

52269

13

56828

20

D3394-043

Manufactured No

110

Each

27.0000

\*\*

4

12

**\*D3394-043\***

Lug Assembly

Location

Loc Qty

Loc Code

ST479

27

74493

27

D4064-041

Manufactured No

110

Each

21.0000

\*\*

1

3

**\*D4064-041\***

Mounting Lug

Location

Loc Qty

Loc Code

ST465

21

58980

4

58985

1

62977

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Work Order ID: 78683

**\*78683\***

Parent Item: D206-628-014

**\*D206-628-014\***

Parent Item Name: Heli-Access-Step RH

Start Date: 12/01/2012

Required Date: 10/02/2012

Start Qty: 3.00

Required Qty: 3.00

MS21043-4

Purchased

No

110

Each

1,038.000

12

36

\*\*

**\*MS21043-4\***

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

470

118086

470

ST301

528

119309

32

119546

496

NAS1149C0363R

Purchased

No

110

Each

3,706.000

2

6

\*\*

**\*NAS1149C0363R\***

Washer

Location

Loc Qty

Loc Code

ST297

3706

114742

3706

NAS1515H3

Purchased

No

110

Each

151.0000

2

6

\*\*

**\*NAS1515H3\***

Washer

Location

Loc Qty

Loc Code

ST277

151

116373

6

118078

6

118384

11

119438

28

120142

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January-12-12 10:55:51 AM

Work Order ID: 78683

**\*78683\***

Parent Item: D206-628-014

**\*D206-628-014\***

Parent Item Name: Heli-Access-Step RH

Start Date: 12/01/2012

Required Date: 10/02/2012

Start Qty: 3.00

Required Qty: 3.00

NAS1515H4L

Purchased

No

110

Each

190.0000

24

72

\*\*

M120390

12/3/05 (3)

**\*NAS1515H4I \***

WASHER

S  
B

Location

Loc Qty

Loc Code

FG

8

103691

8

ST277

182

118709

182

48

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

### 5.2 D206-628-013/-014/-023/-024/-033/-034 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

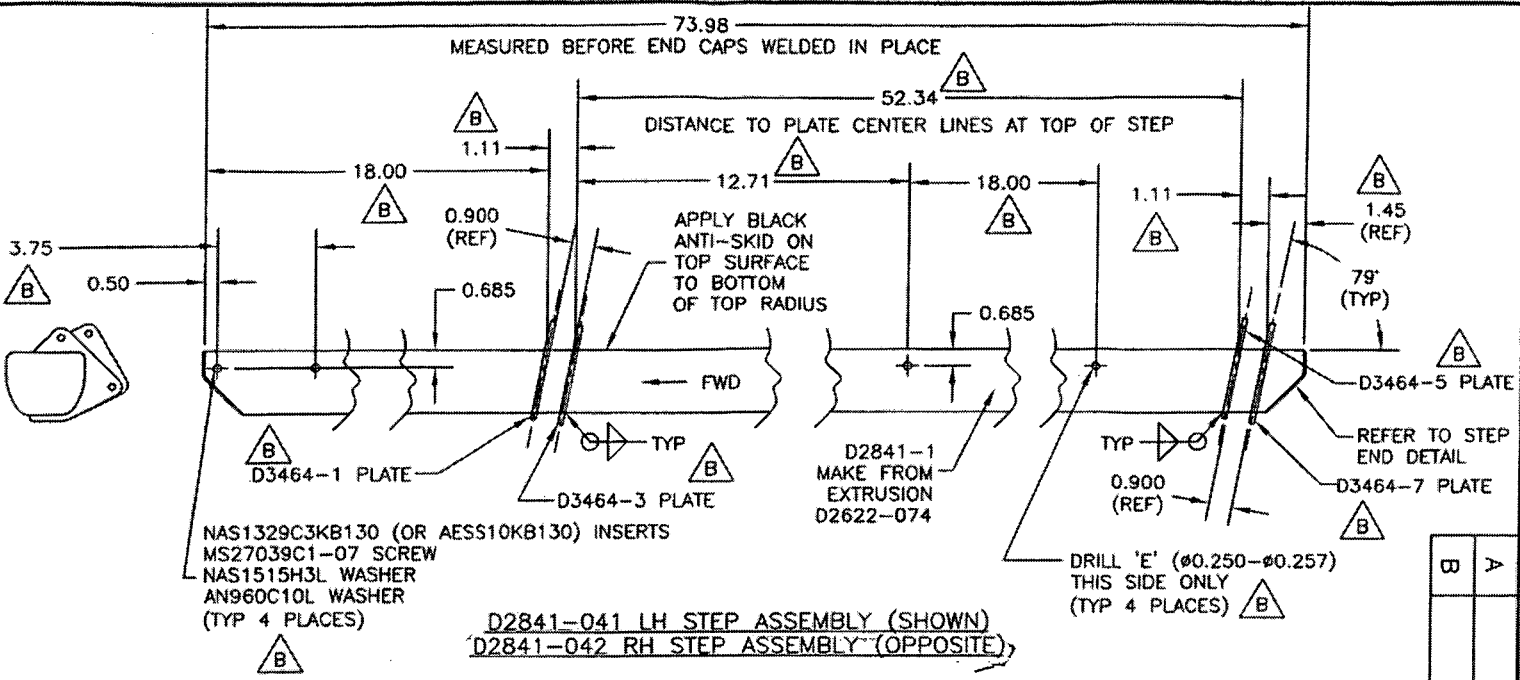
Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1	1					D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*LUG
4	4			8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*LUG
8	8	8	8			*MS35489-93	*GROMMET
1	1					D4064-041	MOUNTING LUG
1	1					*D4064-1	*LUG
2	2					*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	NAS1149C0363R	WASHER (OR AN960C10)
16	16					NAS1149C0463R	WASHER (OR AN960C416)
8	8	24	24	24	24	NAS1149C0432R	WASHER (OR AN960C416L)
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

\*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

### 5.3 QUICK RELEASE PIP PIN KIT

Qty -011	Part Number	Description
X	DSI9235-011	QUICK RELEASE PIP PIN KIT
4	BLRS-020	QUICK RELEASE PIN





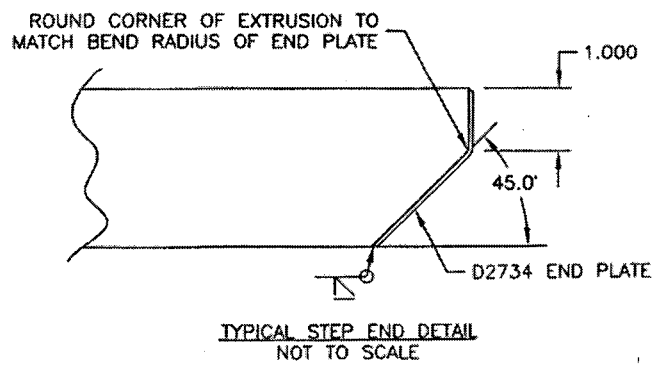
**D2841-041/-042 STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2841-041	LH STEP ASSEMBLY
X	X	D2841-042	RH STEP ASSEMBLY
1	1	D2622-074	EXTRUSION
1	1	D3464-1	PLATE
1	1	D3464-3	PLATE
1	1	D3464-5	PLATE
1	1	D3464-7	PLATE
1	1	D2734	END PLATE
2	2	NAS1329C3KB130 (OR AESS10KB130)	INSERT
4	4	MS27039C1-07	SCREW
4	4	NAS1515H3L	WASHER
4	4	AN960C10L	WASHER

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

**D2841-041/-042 STEP ASSEMBLY**

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED  
05.11.14

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	05.09.21	TITLE	D2841	REV. B
	A	98.10.14	206B FLOAT STEP ASSEMBLY	SHEET 1 OF 1
	B	05.09.21	RE-DESIGN, ADD D2843-1/-3/-5/-7	SCALE
			NEW ISSUE	NTS

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